

Work Order ID 61452

Wednesday, August 25, 2010 12:55:09 PM



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Item ID:	D2844-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Arm					
Start Date:	8/25/2010	Start Qty:	20.00			
Required Date:	9/1/2010	Req'd Qty:	20.00			
Reference:						

Approvals:	Process Plan:	<i>14</i>	Date:	<i>10-8-25</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2844	Rev A								

100		0.00							
	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Form per Dwg D2844 using brake and bending Jig DT 8238-B <input type="checkbox"/> Debur								

110		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

120		0.00							
	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel								
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>9:15</i> <input type="checkbox"/> OVEN TEMPERATURE:								
	<i>400</i> <input type="checkbox"/> FINISH TIME: <i>9:45</i>								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2844-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Arm

Start Date: 8/25/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 9/1/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>ml</u>	<u>10</u>	<u>10</u>	<u>08</u> <u>20</u>
140 QC Quality Control	QC6- Inspect dimensions to drawing Memo ensure parts are still as per dwg D2844	0.00 0.00				<u>10 units</u>	<u>20</u>		
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>265</u> Memo	0.00 0.00							<u>C. 10/00/08</u> <u>(20)</u>

Dart Aerospace Ltd

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Revision ID:

Item Name: Arm

Start Date: 8/25/2010 Start Qty: 20.00

Required Date: 9/1/2010 Req'd Qty: 20.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/12

PS 10-10-12
20

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

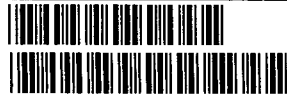
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Work Order ID: 61452

Parent Item: D2844-1

Parent Item Name: Arm



Start Date: 8/25/2010

Required Date: 9/1/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: B□00.11.01□Removed P/O for Powder Coat - in house process□EC□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	85.1807	1.8991	39.98105			
304 RD Tube .500 x .035W													

Location

Loc Qty

Loc Code

MAT

65.215927

114482

41.487777

115180

23.72815

MAT014

19.96082

114356

19.96082

MAT017

0.004

112800

0.004

M115535

39.98105

M-L
10/08/31

W/O:		WORK ORDER CHANGES					
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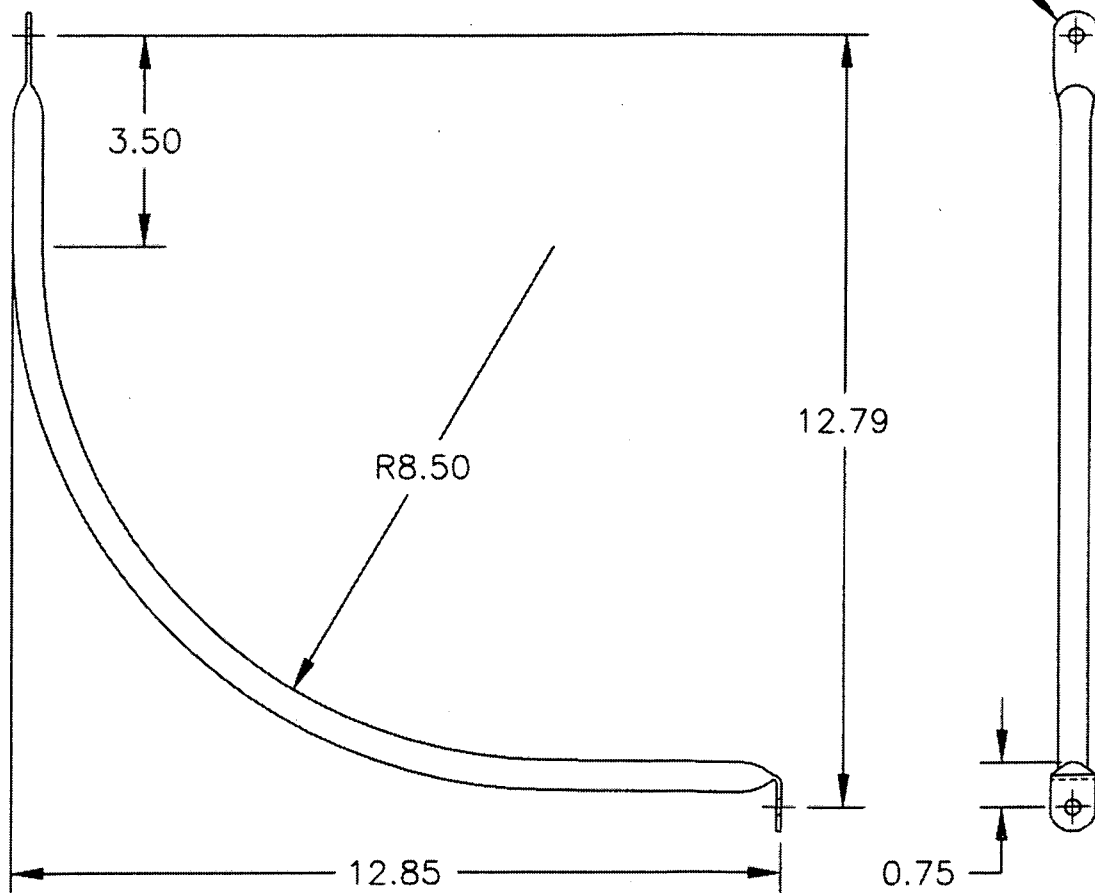
NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DAH</i>	APPROVED <i>CS</i>	DRAWING NO. D2844	REV. A SHEET 1 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3
A	98.10.14	NEW ISSUE	

RELEASED
98.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-1

MATERIAL: AISI 304/316 SS TUBE, $\phi 0.50 \times 0.035$ WALL
ENSURE TUBE IS SEAMLESS
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *61452*

BJO-8-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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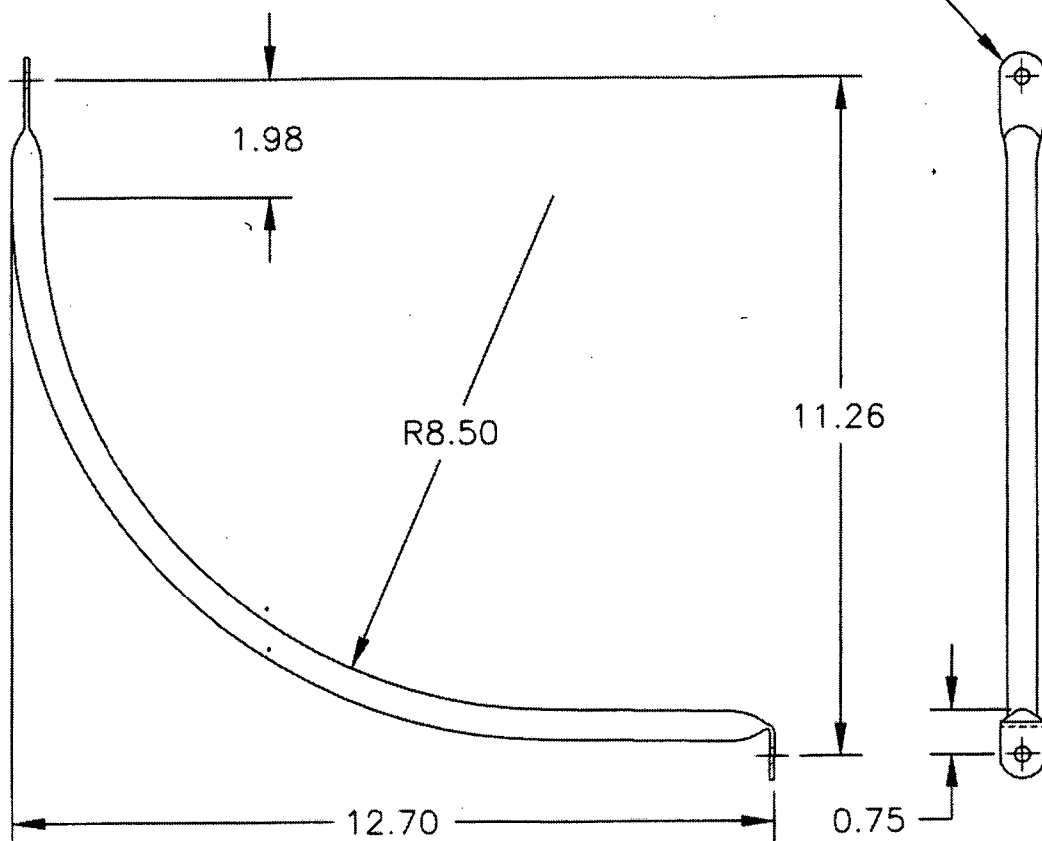
NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DAA</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2844	REV. A SHEET 2 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3

RELEASED
98.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



w/o 61452

D2844-3

MATERIAL: AISI 304/316 SS TUBE, $\phi 0.50 \times 0.035$ WALL
ENSURE TUBE IS SEAMLESS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

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